

Work Order ID 53285

October 30, 2009 1:21:42 PM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date:

09-10-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A *[Signature]*

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <i>7/112507 / 7/111999 BE 09/11/02</i>								
	4-Grind weld flush to cap on top surface only. <i>BE 09/11/02</i>								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650								
	11-Deburr and Blow out all chips form inside the tube								

1 H 9/11/12

1 H 9/11/13

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Start Date: 29/10/2009 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes									
Skidtubes	QC5	0.00	2) Solutus			(EO)	f		
	Memo								
	Install D2680-041 Nut plate as per Dwg								
130		0.00							
QC									
Quality Control									
	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00	2) Solutus			(EO)	f		

10/9/11/03 - Chemical conversion
- QC3

AWN 9-11-3

11/9/11/3

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting

Start Date: 7/11/03 Time: 4:00

Finish Date: 9/11/04 Time: 8:20 AM

A/R ☐ Sikaflex-291 ☐ M112391

Sikaflex expiry date: 10-02-20

3 BE 09/11/03

Hum 9-11-3

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8071604

46

8

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod M112507

BE 09/11/05

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

AWM 9-11-06

165

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

1 09-11-10

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Accept

**Setup Start**

Stop

**Cust Item ID:**

Customer:

Run Start

Stop

[illegible]

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Item ID: D206-642-441

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Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00



HandFinish

Handwritten: e Alodine (touch-up) => Hl 09/11/10

Memo

0.00

(X)

0

Hand Finishing

205

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

*PRIME GREY 110918
SPRAY PAINT DELFLEET BLUE 110077
CLEAR DELFLEET 113088*

m/ 09 11 11 (1)

Spray Painting

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

09-1172

Quality Control

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Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ 11/12/30/1

Sikaflex expiry date: ☐ 10/01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☒ 11/12/30/1

Sikaflex expiry date: ☐ 10/01

6-Wing Walk as per Dwg D2650.7 and QSI 005 4.4

Batch: 11.112623

BK 09-11-17

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Setup Start



Revision ID: F

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Item Name: Replacement Skidtube

Start Date: 29/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

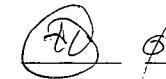
⇒ 80% h7



QC

Memo

0.00



Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

B53288

PPP

9/11/18 WSP

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/11/19 HJ

Quality Control

W 09.11.18

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Work Order ID: 53285



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB		Manufactured	No			110	Each	13.0000	1.0000			
Skidtube, 206 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

13

45898

13

D2646RevC		Manufactured	No			120	Each	44.0000	1.0000			
Aft Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

44

20208

0

43801

1

46327

4

48109

39

D2647RevF		Manufactured	No			140	Each	23.0000	1.0000			
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

23

10773

7

43846

16

1 09/11/02

1 09/11/02

1 09/11/02

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Work Order ID: 53285



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2654-7RevE1

Manufactured

No

160

Each

2.0000

1.0000



Web

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

52801

2

CCR264SS3-3

Purchased

No

170

Each

65.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

111548

38

111827

1

112314

26

B 52817 * AWM 9-11-03

AWM 9-11-06 (2)

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Work Order ID: 53285



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			170	Each	476.0000	23.0000			
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 83

51529 83

Main Warehouse

ST 393

36013 5

47112 382

48271 6

23 BE 09/11/05

D2680-041RevB1

Manufactured No

170

Each

75.0000

1.0000



Nut Plate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 75

33061 10

44086 65

AWM 9-11-06

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Work Order ID: 53285



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	5,073.000	60.0000			

Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

5073

110511 ✓

5073

AN9601D10L AN960C10L

Purchased

No

230

Each

5,735.000

62.0000



Washer

409.11.12

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

5735

101291

16

104885

153

105793

236

109632 ✓

420

110985

4910

60 09-11-17.

RO

2 09-11-17.

W/O: 53285		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.12	230	Qty (60) AN960 JD10L REPLACED WITH Qty (60) AN960 CIDL 112612	BR	09-11-16	60.	09.11.12 P. [Signature] 09/11/12	09/11/12

Part No: D206-642-441 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53285



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			230	Each	4,591.000	1.0000			
Washer												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

4591

108161

519

110523

340

111279

101

111916

482

112314 ✓

3149

16941

0

1 09-11-17

CR3212-4-03

Purchased

No

230

Each

292.0000

2.0000



Cherry Rivet

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

292

111359

92

112314

200

AWM 9-11-06

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Work Order ID: 53285



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1RevB		Manufactured	No			230	Each	359.0000	22.0000			

Plug

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST 53349	359	
43990	81	
45490	28	
51530	250	

22 BR 09-11-17

D2651-3RevB

Manufactured No

230

Each

991.0000

22.0000



O-Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	991	
43849	3	
46114 ✓	988	

22 BR 09-11-17

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Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-15RevB		Manufactured	No			230	Each	22.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	17	
51671 ✓	17	
Main Warehouse		
ST	5	
30750	4	
42233	1	

1 6102-11-17

D3535-23RevB Manufactured No



Wearshoe

230 Each 15.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
51618 ✓	13	
Main Warehouse		
ST	2	
48156	2	

1 6101-11-17

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Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-37RevB		Manufactured	No			230	Each	18.0000	1.0000			

Wearshoe

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

FP

13

51654 ✓

13

Main Warehouse

ST

5

47374

5

D3536-15RevA

Manufactured

No

230

Each

32.0000

1.0000



Gasket

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

32

48159

6

51600 ✓

26

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Required Date: 09/11/2009

Comments:

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			230	Each	21.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51609 ✓

12

Main Warehouse

ST

9

30754

1

47713

8

D3536-37RevA

Manufactured

No

230

Each

20.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

20

47375 ✓

7

51641

13

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Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			230	Each	299.0000	6.0000			

Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	2	
48288	2	
Main Warehouse		
FP17	297	
51624	30	
51678 ✓	162	
51679	105	

6 10/09-11-17.

D3537-3RevC

Manufactured No

230

Each

60.0000

1.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	60	
30758	7	
33881 ✓	17	
35697	36	

1 10/09-11-17

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Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			230	Each	2,947.000	2.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2947	
110467 ✓	188	
110552	759	
110835	2000	

2 BK 09-11-17.

MS27039-4-06		Purchased	No			230	Each	75.0000	1.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	75	
109061 ✓	75	

1 BK 09-11-17.

MS27039C1-08		Purchased	No			230	Each	962.0000	60.0000			
SCREW												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	962	
19185 ✓	962	

60 BK 09-11-17.

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Shop Packet Print

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

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NOTES:

MATERIAL: N/A
FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX

IDENTIFICATION: NONE

WEIGHT: N/A

WELD PER DART QSI 004

DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

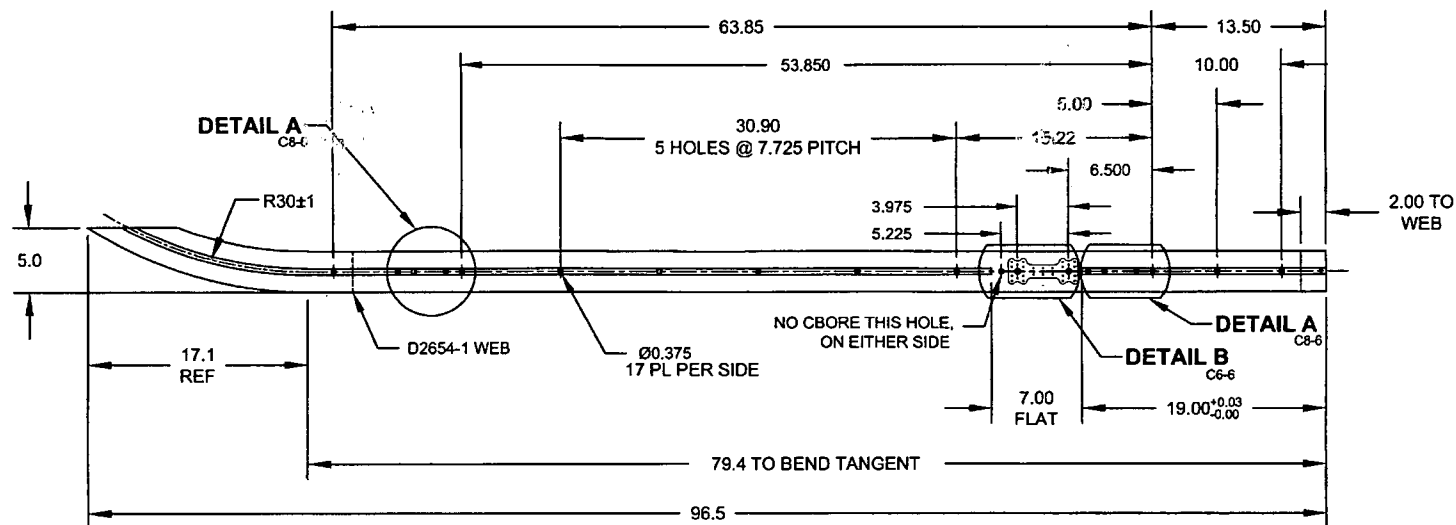
) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015

) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.

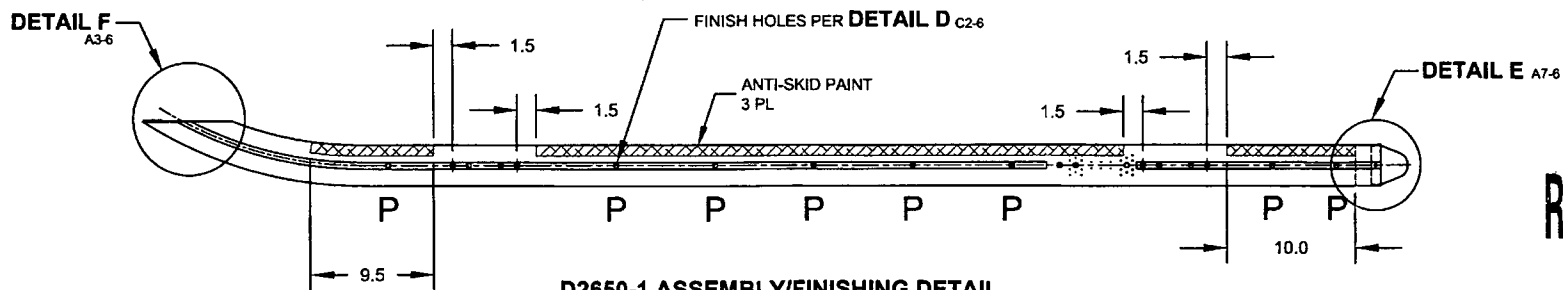
) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
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D2650-1 BENDING/DRILLING DETAIL

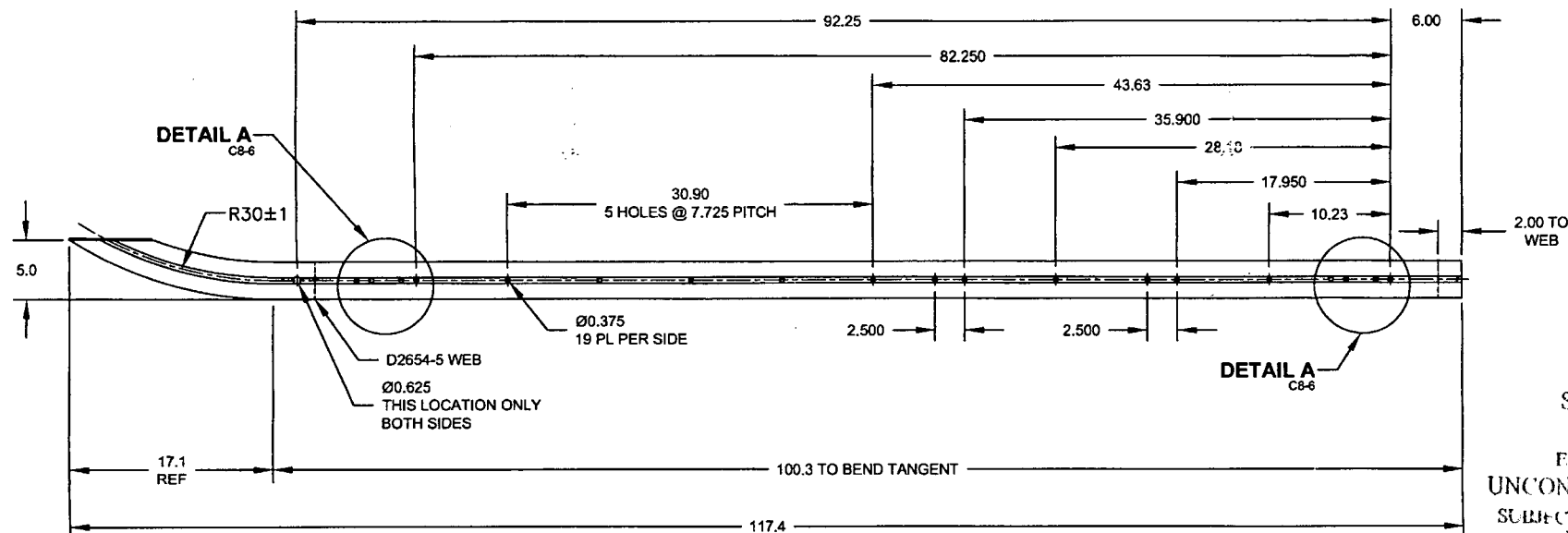
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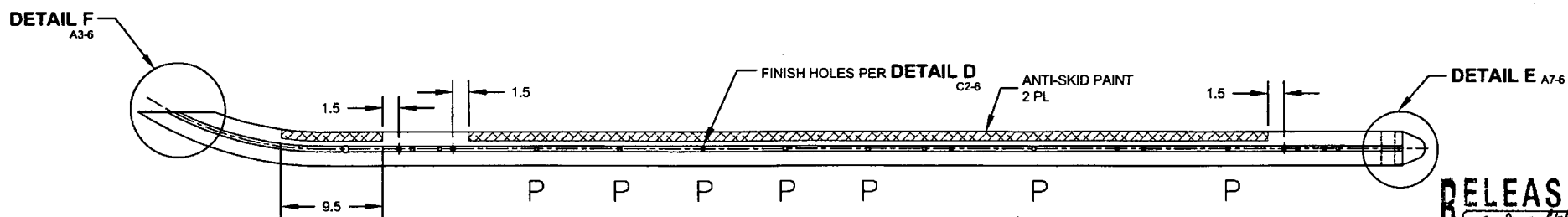
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D2650-5 BENDING/DRILLING DETAIL

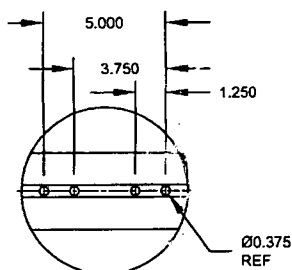
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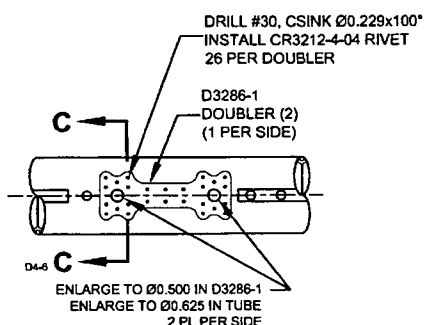
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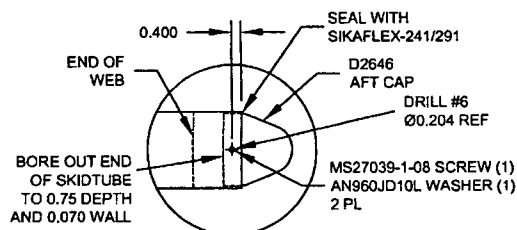
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DETAIL A C2-2
SCALE 2X D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

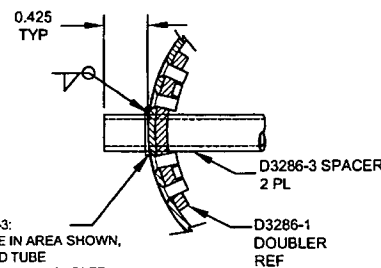


DETAIL B C3-2
SCALE 2X C3-3

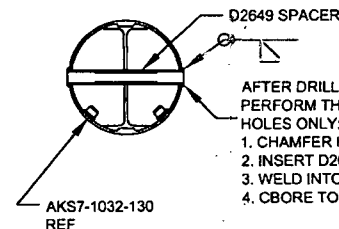


DETAIL E B2-2
SCALE 2X B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE



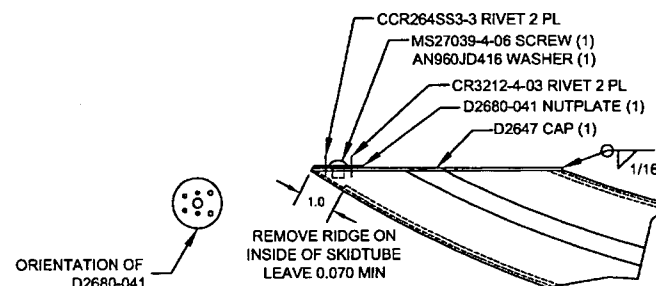
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D B4-2
FOR Ø0.375 HOLES ONLY B4-3
SCALE 3X B4-4
B4-5

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP




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DETAIL F B8-2
SCALE NONE B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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